

Work Order ID 133615

Thursday, June 11, 2015 2:43:22 PM

133615

Page 1

Item ID: D5203-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Weldment

Start Date: 6/11/15 Start Qty: 1.00

Required Date: 6/12/15 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 15-6-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5203

A

110 Weld per dwg A/R S.S. rod Batch: 1123823 0.00

110

Large Fab

Memo

0.00

Large Fab

Weld stud to strut as per dwg

GRIND WELD FLUSH

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

1 PL 15-6-11

JUN 11 2015

DAS
24
9-89

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DAS
24
9-89

Work Order ID 133615

133615

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Thursday, June 11, 2015 2:43:22 PM

Item ID: D5203-045 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Strut Weldment
Start Date: 6/11/15 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/12/15 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS JUN 12 2015
MCS JUN 12 2015

Picklist Print

Thursday, June 11, 2015 2:43:29 PM

Page 1

Work Order ID: 133615

133615

Parent Item: D5203-045

D5203-045

Parent Item Name: Strut Weldment

Start Date: 6/11/15

Required Date: 6/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.01.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN665-34R *AN665-34R* Clevis		Purchased	No				Each	26.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST330				26					
				M130388				8					
				M132317				18		2			
D4794-3 *D4794-3* Stud		Manufactured	No				Each	4.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				4					
				129380				4					
D5203-1 *D5203-1* Strut		Manufactured	No				Each	0.0000		1			
NAS509-4C *NAS509-4C* NUT		Purchased	No				Each	17.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST262				17					
				M130466				7		2			
				M131584				10					

FF

JUN 11 2015

2

2

**

1 15.6.11

**

15.6.11

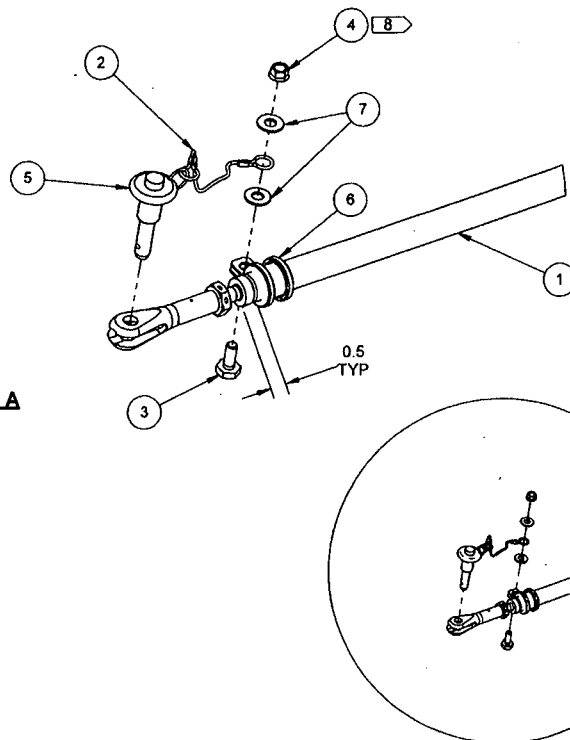
**

FF

JUN 11 2015

2

DETAIL A



D5203-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.95 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

ITEM	QTY	P/N	DESCRIPTION
	X	D5203-041	STRUT ASSEMBLY
1	1	D5203-045	STRUT WELDMENT
2	2	D2690-6	LANYARD ASSEMBLY
3	2	AN3C3A	BOLT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	MS17984-C405	PIN, QUICK RELEASE (NASM17984-C405)
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

RELEASED

2015 JAN 29

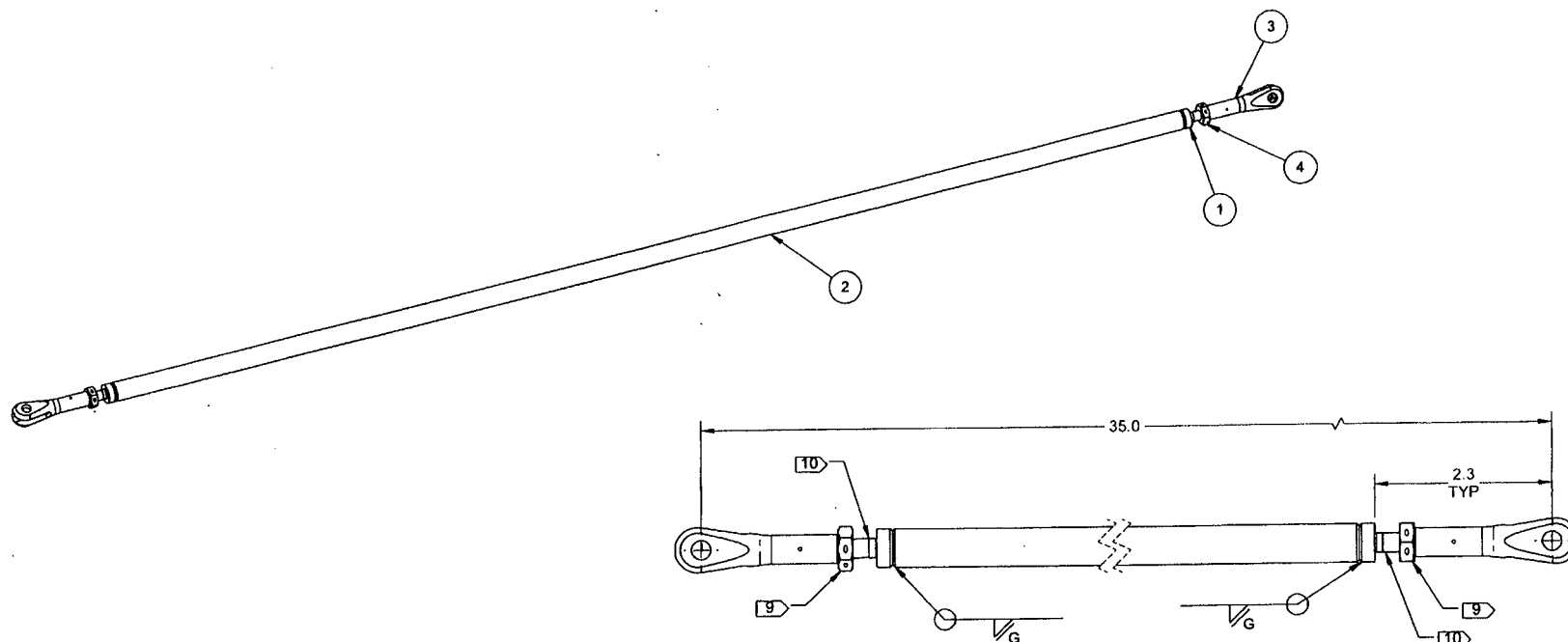
ECN 15-508 9

A	NEW ISSUE	RF	14.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

DS-6-10

ITEM	QTY -045	P/N	DESCRIPTION
	X	D5203-045	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5203-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5203-045 STRUT WELDMENT

RELEASED

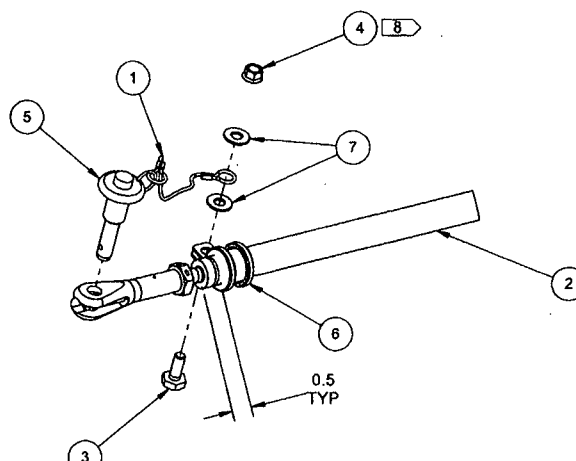
2015 JAN 29 *up*

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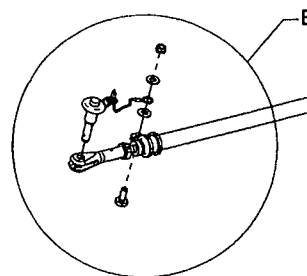
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

APPROVED

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DATE	14.12.19		



DETAIL B



D5203-043 STRUT ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D5203-043	STRUT ASSEMBLY
1	2	O2690-6	LANYARD ASSEMBLY
2	1	D5203-047	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	MS17984-C405	PIN, QUICK RELEASE (NASM17984-C405)
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.19 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

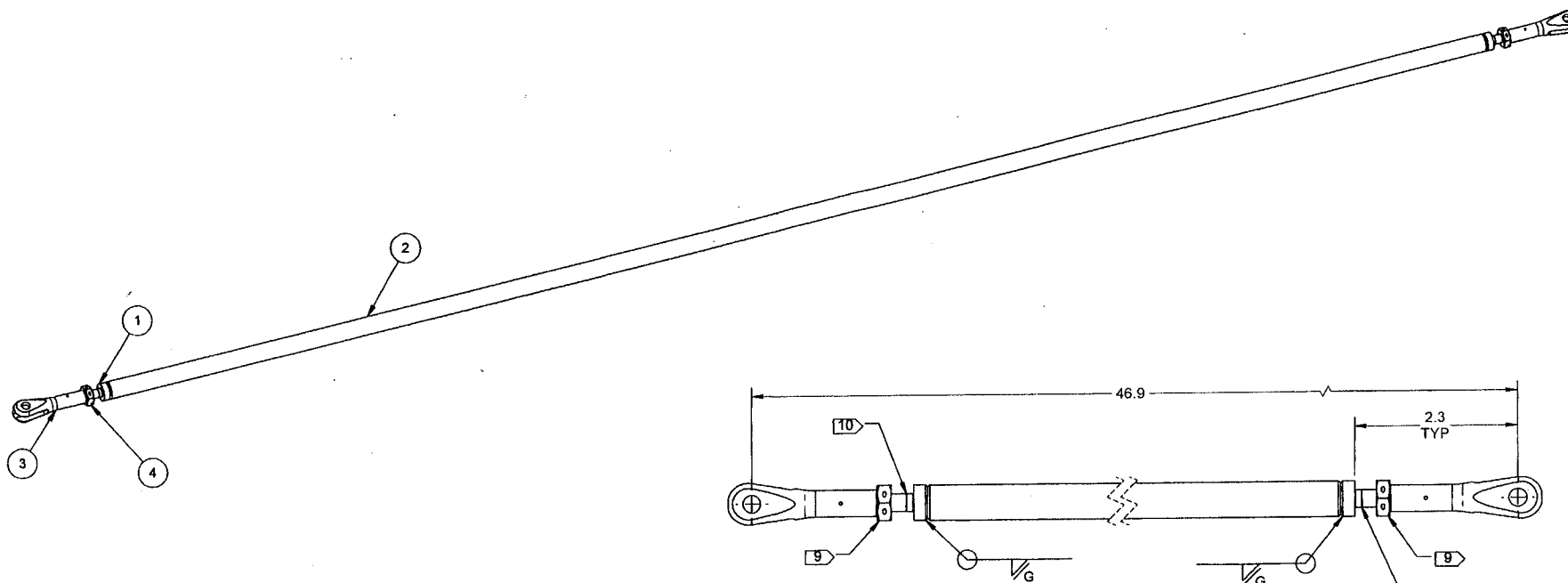
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D5203-047	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5203-3	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5203-047 STRUT WELDMENT

RELEASED

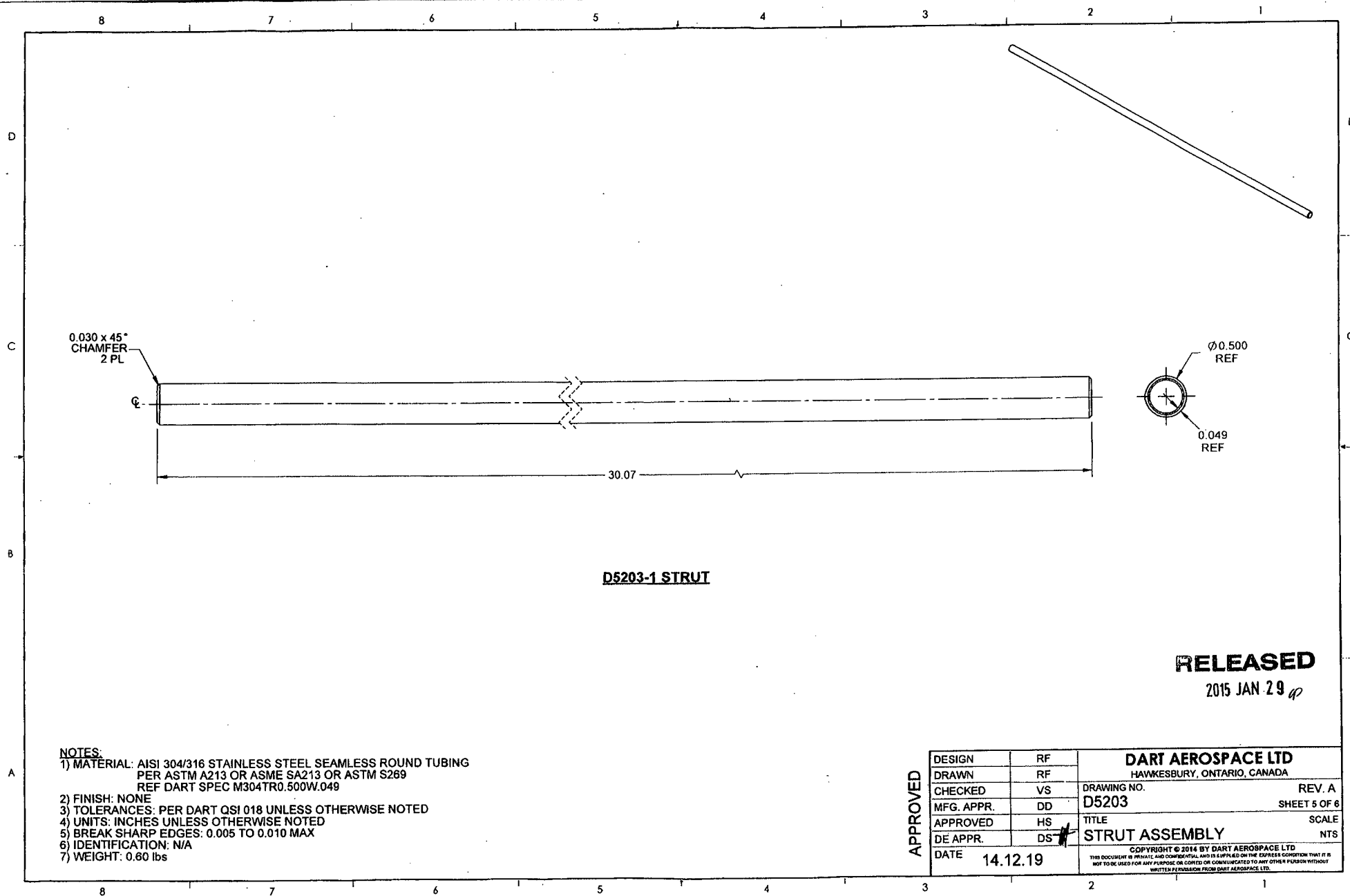
2015 JAN 29 *qr*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.06 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

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D5203-1 STRUT

RELEASED
2015 JAN 29 *qp*

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.60 lbs

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	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STRUT ASSEMBLY	NTS
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0.030 x 45°
CHAMFER
2 PL

Ø

42.00

Ø0.500
REF

0.049
REF

D5203-3 STRUT

RELEASED

2015 JAN 29

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500V.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.84 lbs

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